

Please cut ASAP

Work Order ID 147746

June 10, 2016 1:19:21 PM

147746

Ship June 21

Page 1

Item ID: D4268-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Instrument Panel

Start Date: 6/10/2016 Start Qty: 1.00

1

Cust Item ID: 0

Required Date: 6/21/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

SUA

Date:

6/10/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4268

A

100

0.00

100

Waterjet

Memo

0.08

FLOW CNC Waterjet

1-Cut as per Dwg (D4268-3)

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

2

De 16/06/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2

De 16/06/10

June 10, 2016 1:19:21 PM

Page 2

Reference:

Stop ***NR2***

[illegible]

June 10, 2016 1:19:21 PM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 6/10/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/21/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.09

Hand Finishing

160

0.00

160

SprayPaint

Memo

0.20

Spray Painting

Prime per QSI 005 4.2.1 and as per dwg

PRIMER BATCH: 134454

170

QC14- Inspect Spray Paint

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89
JUN 16 2016

June 10, 2016 1:19:21 PM

Page 4

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NB2***

[illegible]

Work Order ID 147746

June 10, 2016 1:19:21 PM

147746

Page 5

Item ID: D4268-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Instrument Panel
Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/21/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

JUN 21 2016

JUN 21 2016

Picklist Print

June 10, 2016 1:19:26 PM

Page 1

Work Order ID: 147746

147746

Parent Item: D4268-043

D4268-043

Parent Item Name: Instrument Panel

Start Date: 6/10/2016

Required Date: 6/21/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.04 new issue DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 *MS20426AD3-3* RIVET		Purchased	No			180	Each	1,497.000	6	6		16/06/16	DAS 36 9-89

Location	Loc Qty	Loc Code
GA	550	
M131624	550	
ST312	947	
M131624	947	

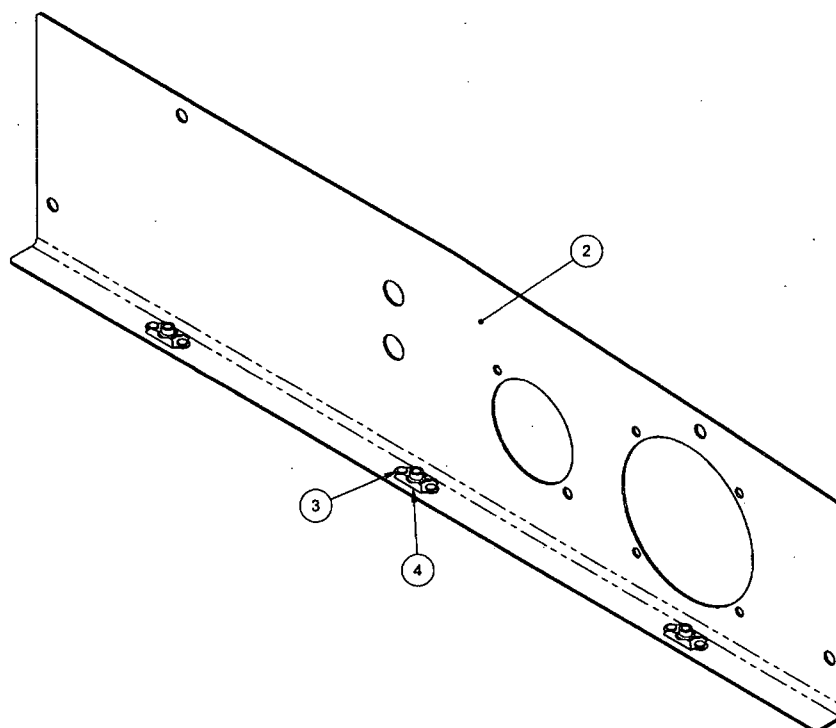
MS21059L3 *MS21059L3* Nut Plate		Purchased	No			180	Each	60.0000	3	3		16/06/16	DAS 36 9-89
--	--	-----------	----	--	--	-----	------	---------	---	---	--	----------	-------------------

Location	Loc Qty	Loc Code
CA	8	
M129682	8	
ST301	26	
M134762	26	
ST303	26	
M133016	26	

M2024T3S.040 *M2024T3S 040* 2024-T3 .040 sheet		Purchased	No			100	sf	91.9000	0.0744	0.078316		06/16/06/10	
---	--	-----------	----	--	--	-----	----	---------	--------	----------	--	-------------	--

Location	Loc Qty	Loc Code
MAT022	91.9	
m134532	43.9	
m134774	48	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4268-041	INSTRUMENT PANEL ASSEMBLY, (205)
2	1	D4268-1	INSTRUMENT PANEL, (205)
3	6	MS20426AD3-3	RIVET
4	3	MS21059L3	ANCHOR NUT



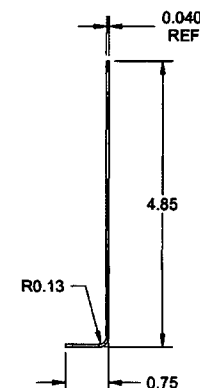
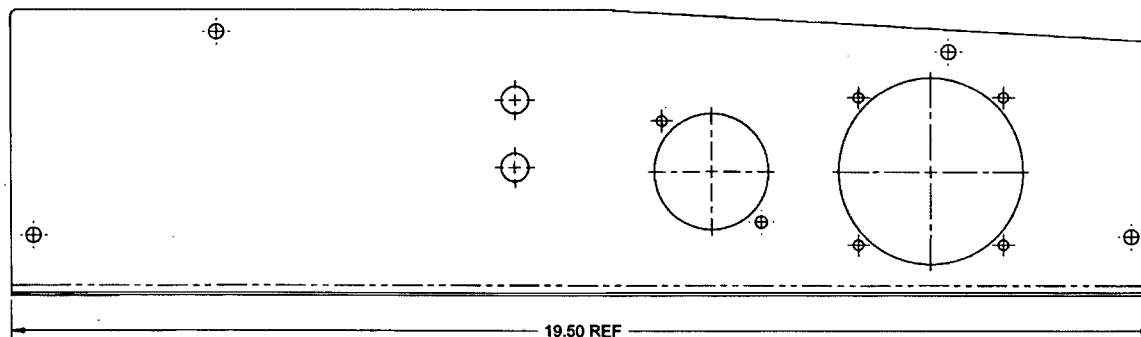
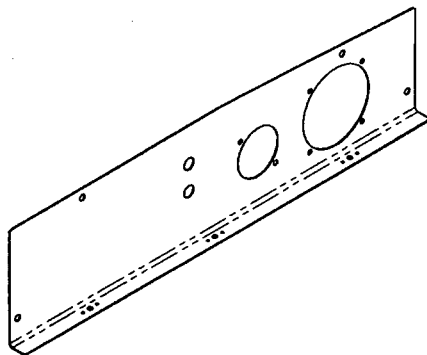
D4268-041 INSTRUMENT PANEL ASSEMBLY, (205)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-205)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs

54
147746
6/10/10.
RELEASED
2011-04-06
JM

A NEW ISSUE		RF	11.02.07
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 1 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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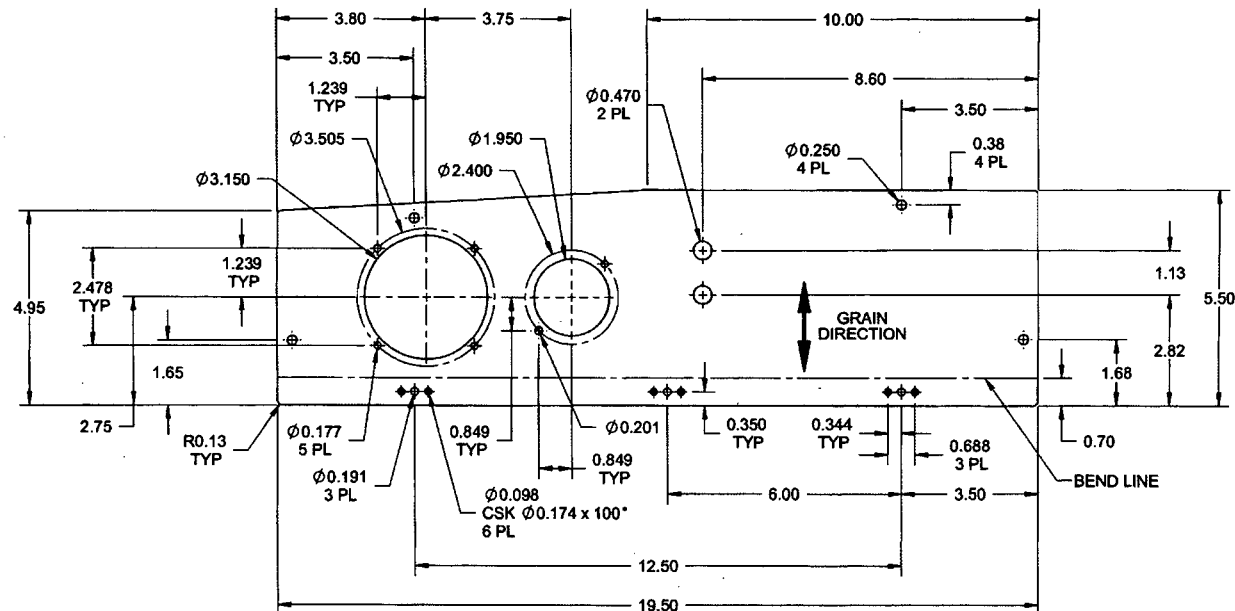
D4268-1 INSTRUMENT PANEL, (205)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-205)

RELEASED
R 2011-04-06

NOTES:

- 1) MATERIAL: MAKE FROM D4268-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 2 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D4268-1F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-205)

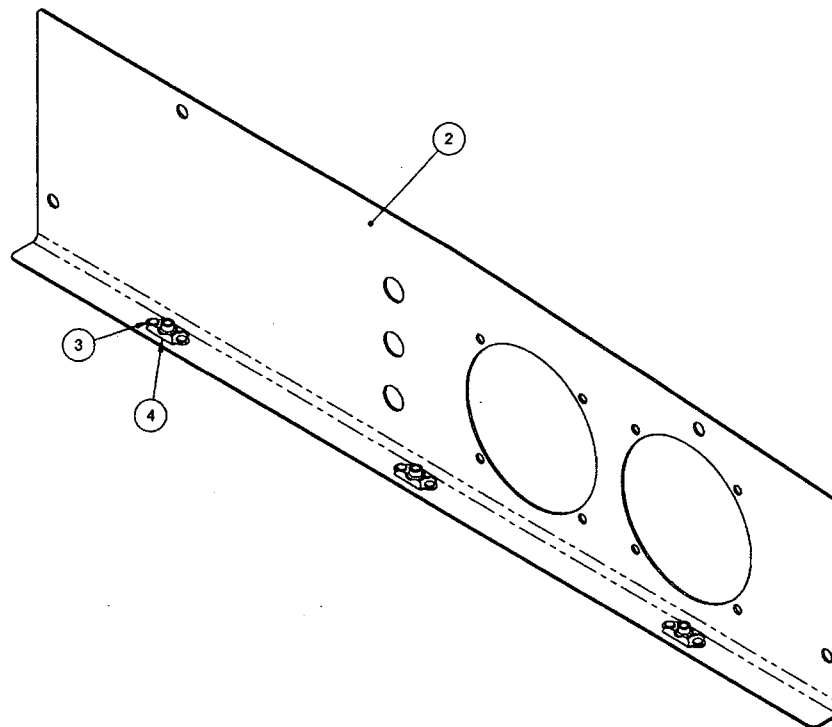
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs

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2011-04-08
JMB

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 3 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4268-043	INSTRUMENT PANEL ASSEMBLY, (212/412)
2	1	D4268-3	INSTRUMENT PANEL, (212/412)
3	6	MS20420AD3-3	RIVET
4	3	MS21059L3	ANCHOR NUT



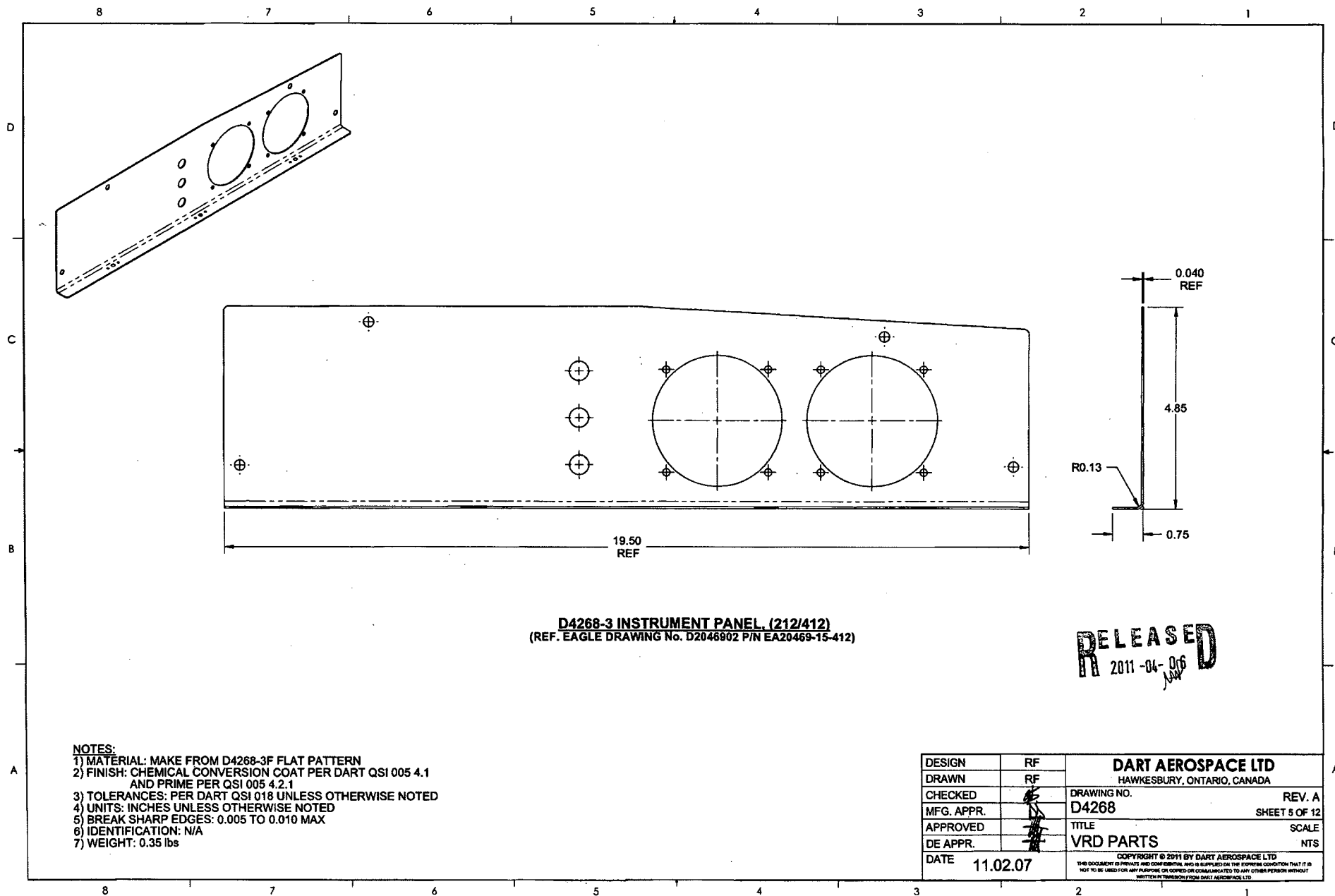
D4268-043 INSTRUMENT PANEL ASSEMBLY, (212/412)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

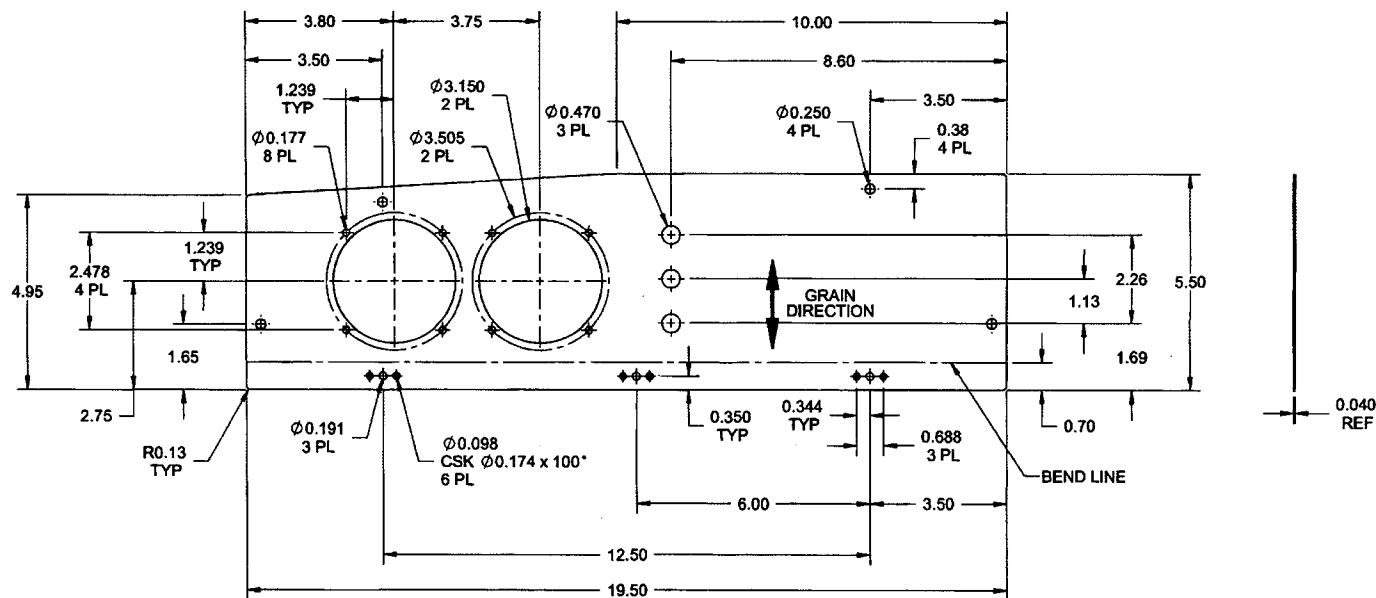
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.35 lbs

RELEASED
2011-04-08
JM

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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D4268-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

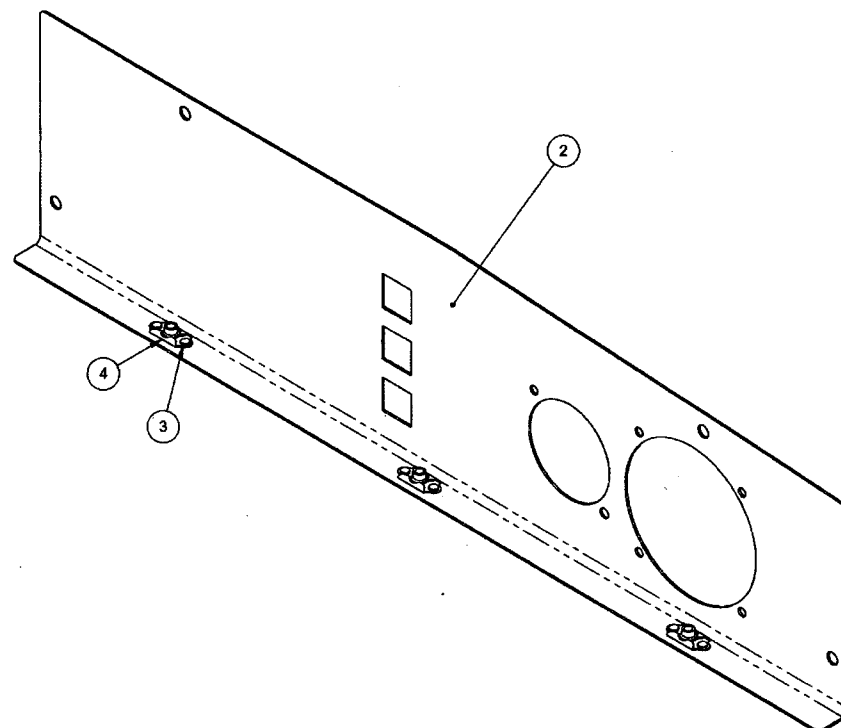
RELEASED
2011-04-06
N/A

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4268-045	INSTRUMENT PANEL ASSEMBLY, (EAGLE SINGLE)
2	1	D4268-5	INSTRUMENT PANEL, (EAGLE SINGLE)
3	6	MS20426AD3-3	RIVET
4	3	MS21059L3	ANCHOR NUT



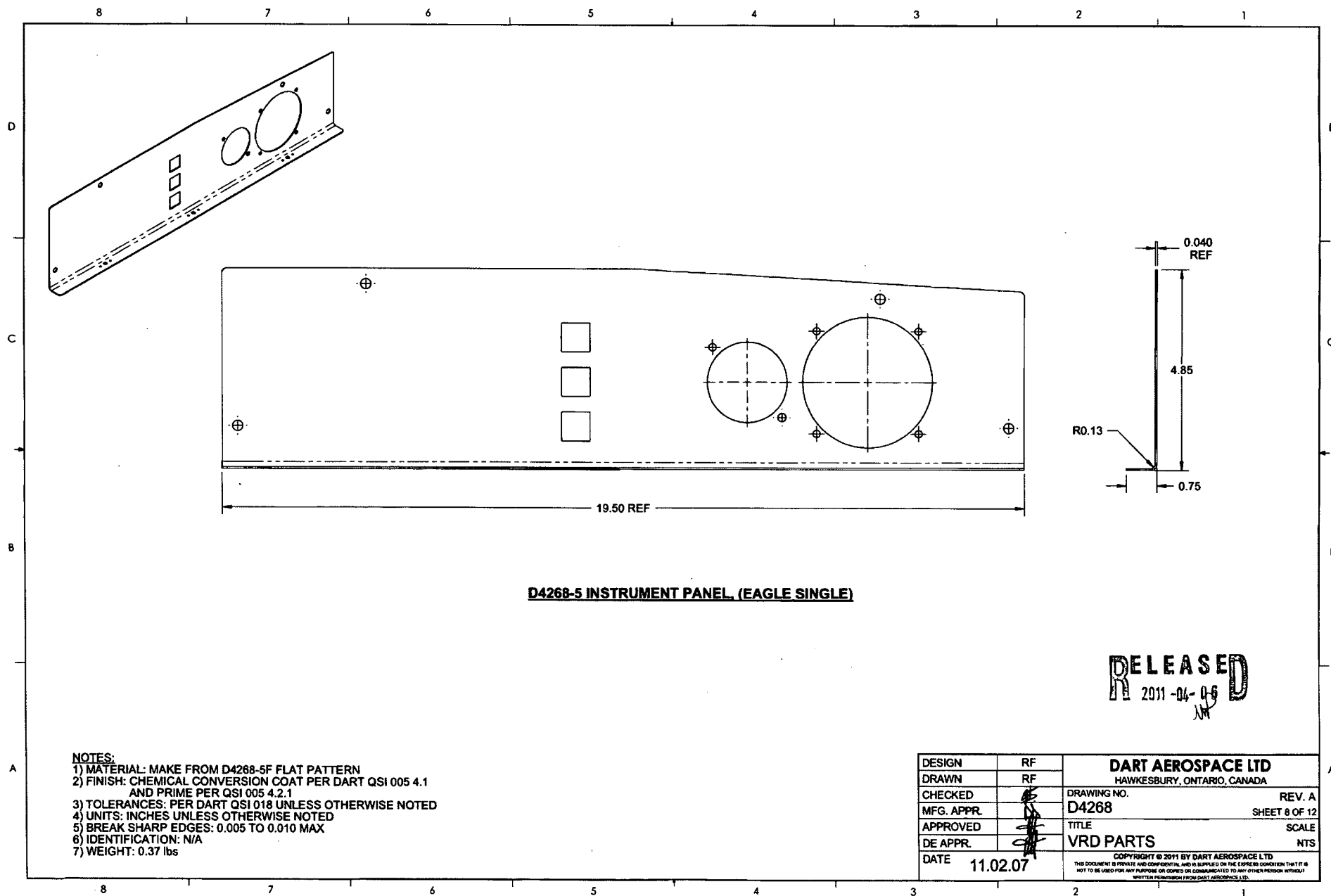
D4268-045 INSTRUMENT PANEL ASSEMBLY, (EAGLE SINGLE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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R 2011-06-05
JW

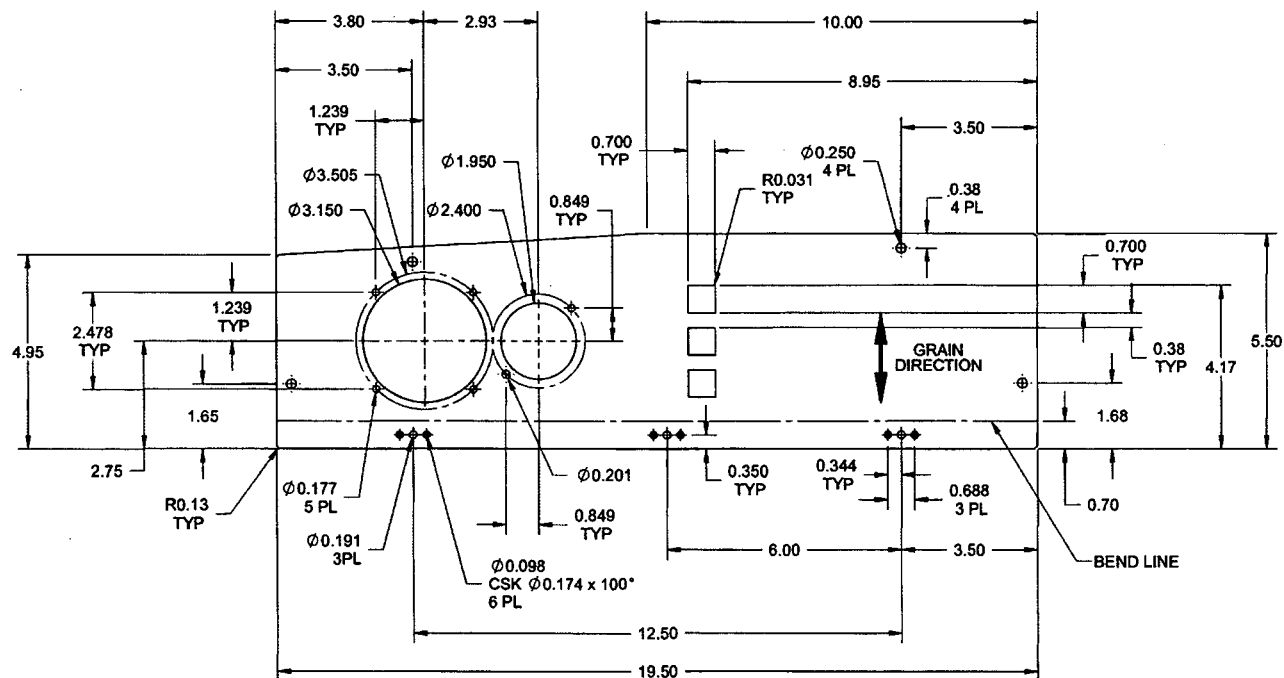


NOTES:

- 1) MATERIAL: MAKE FROM D4268-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 8 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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2011-04-06
[Signature]



D4268-5F FLAT PATTERN

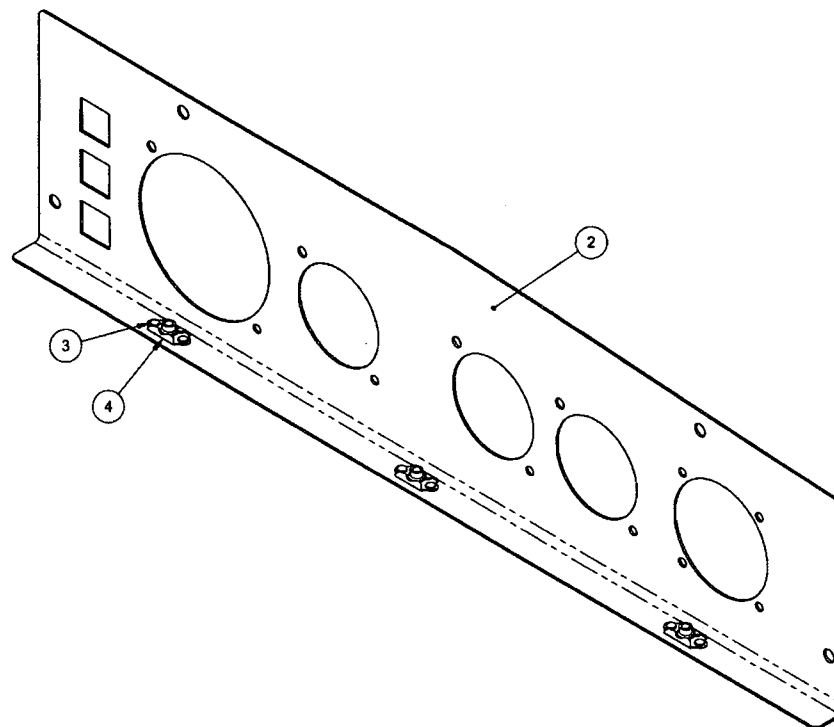
RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4268	SHEET 9 OF 12
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4268-047	INSTRUMENT PANEL, (EAGLE SINGLE - OPTIONAL)
2	1	D4268-7	INSTRUMENT PANEL, (EAGLE SINGLE - OPTIONAL)
3	6	MS20426AD3-3	RIVET
4	3	MS21059L3	ANCHOR NUT



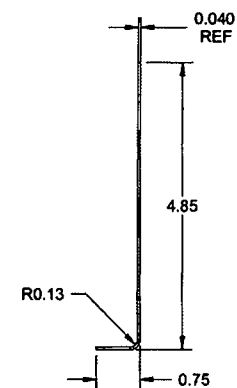
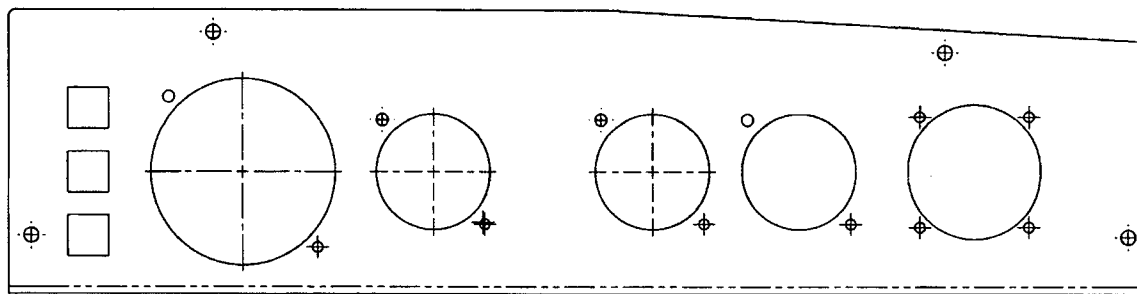
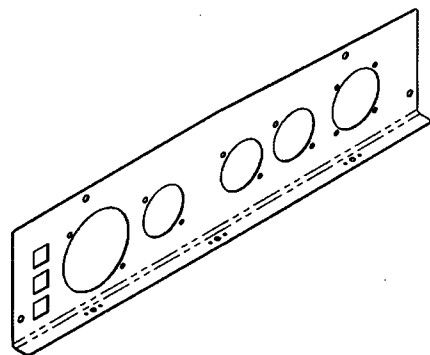
D4268-047 INSTRUMENT PANEL ASSEMBLY, (EAGLE SINGLE - OPTIONAL)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 10 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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RELEASED
2011-04-06



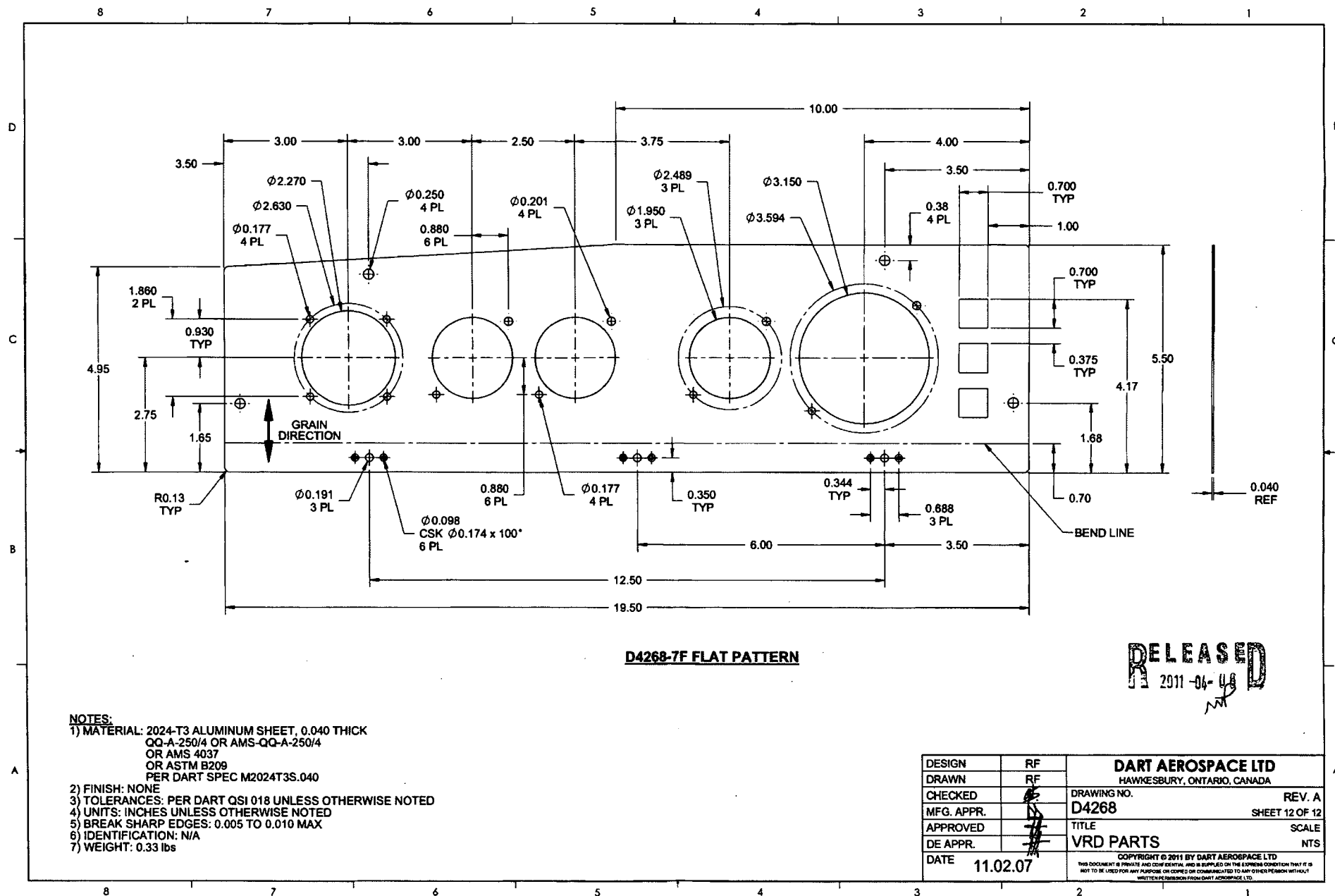
D4268-7 INSTRUMENT PANEL (EAGLE SINGLE - OPTIONAL)

RELEASED
2011-06-06
JN

NOTES:

- 1) MATERIAL: MAKE FROM D4268-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4268	SHEET 11 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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DART AEROSPACE LTD		Work Order:	147746
Description: Instrument Panel		Part Number:	D4268-3
Inspection Dwg: D4268 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.097	/		V.D-02	
Ø0.177	+0.005/-0.001	Ø.178	/		Tap	
Ø0.191	+0.005/-0.001	Ø.193	/			
Ø0.250	+0.005/-0.001	Ø.249	/			
Ø0.470	+0.006/-0.001	Ø.469	/			
Ø3.150	+0.012/-0.001	Ø3.151	/			
Ø3.505	+0.012/-0.001	Ø3.504	/			
4.95	+/-0.030	4.95	/			
2.478	+/-0.010	2.477	/			
1.239	+/-0.010	1.240	/			
1.65	+/-0.030	1.65	/			
2.75	+/-0.030	2.75	/			
19.50	+/-0.030	19.50	/			
12.50	+/-0.030	12.50	/			
6.00	+/-0.030	6.00	/			
3.50	+/-0.030	3.50	/			
0.350	+/-0.010	.352	/			
0.344	+/-0.010	.343	/			
0.688	+/-0.010	.689	/			
1.69	+/-0.030	1.69	/			
1.13	+/-0.030	1.13	/			
2.26	+/-0.030	2.26	/			
5.50	+/-0.030	5.50	/			
0.38	+/-0.030	.38	/			
3.50	+/-0.030	3.50	/			
8.60	+/-0.030	8.60	/			
10.00	+/-0.030	10.00	/			
3.80	+/-0.030	3.80	/			
3.75	+/-0.030	3.75	/			
3.50	+/-0.030	3.50	/			
1.239	+/-0.010	1.240	/			
0.040	+/-0.010	.040	/			

Measured by:	D	Audited by:	38	Preliminary Approval:	
Date:	16/06/10	Date:	JUN 11 2016	Date:	

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	